



Dart Aerospace Ltd.  
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Canada

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**RBE350A93-3201-00**  
**Job Sheet 194253**



**Part No:** RBE350A93-3201-00

**Job Qty:** 2 pcs

**Part Name:** Power Rings Bushing Extractor



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 4/29/19

**Job Tracking No:**

**Due Date:** 6/25/19

**Created By:** Marie Lajeunesse

**Type:** SOLD

**Description:** *order 15422*

**Note:** DWG RBE350A93-3201-00 Rev 1 IPP Rev. A 19.04.26 New issue DP Verify DD

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation                   | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off                                                                           |
|-------|-----------------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|------------------------------------------------------------------------------------|
|       |                             |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |                                                                                    |
| 100   | Small Fab - 1               | 2 pcs | 6/25/19    |          | 0.00      | 0.17    | Small Fab - 1         |           | <i>M/L</i>                                                                         |
|       |                             |       |            |          |           |         | Small Fab - 2         |           |                                                                                    |
|       |                             |       |            |          |           |         | Small Fab - 3         |           |                                                                                    |
|       |                             |       |            |          |           |         | Small Fab - 4         |           |                                                                                    |
|       |                             |       |            |          |           |         | Small Fab - 5         |           |                                                                                    |
|       |                             |       |            |          |           |         | Small Fab - 6         |           |                                                                                    |
|       |                             |       |            |          |           |         | Small Fab - 7         |           |                                                                                    |
| 110   | QC 5                        | 2 pcs | 6/25/19    |          | 0.00      | 0.00    | QC 5 - 10             |           |                                                                                    |
|       |                             |       |            |          |           |         | QC 5 - 12             |           |                                                                                    |
|       |                             |       |            |          |           |         | QC 5 - 17             |           |                                                                                    |
|       |                             |       |            |          |           |         | QC 5 - 18             |           |                                                                                    |
|       |                             |       |            |          |           |         | QC 5 - 19             |           |                                                                                    |
|       |                             |       |            |          |           |         | QC 5 - 22             |           |                                                                                    |
|       |                             |       |            |          |           |         | QC 5 - 24             |           |                                                                                    |
|       |                             |       |            |          |           |         | QC 5 - 3              |           |                                                                                    |
|       |                             |       |            |          |           |         | QC 5 - 43             |           |                                                                                    |
|       |                             |       |            |          |           |         | QC 5 - 49             |           |                                                                                    |
|       |                             |       |            |          |           |         | QC 5 - 51             |           |                                                                                    |
|       |                             |       |            |          |           |         | QC 5 - 58             |           |                                                                                    |
|       |                             |       |            |          |           |         | QC 5 - 68             |           |                                                                                    |
|       |                             |       |            |          |           |         | QC 5 - 9              |           |                                                                                    |
|       |                             |       |            |          |           |         | QC 5 - 50             |           |                                                                                    |
|       |                             |       |            |          |           |         | QC 5 - 30             |           |                                                                                    |
| 130   | Packaging 3-1 - Stock - B4B | 2 pcs | 6/25/19    |          | 0.00      | 0.00    | Packaging 3 - 1 - B4B |           | <div style="text-align: right;"> <b>DAS</b><br/> <b>40</b><br/> <b>9-89</b> </div> |
|       |                             |       |            |          |           |         | Packaging 3 - 2 - B4B |           |                                                                                    |
|       |                             |       |            |          |           |         | Packaging 3 - 3 - B4B |           |                                                                                    |
|       |                             |       |            |          |           |         | Packaging 3 - 4 - B4B |           |                                                                                    |
|       |                             |       |            |          |           |         | Packaging 3 - 5 - B4B |           |                                                                                    |
|       |                             |       |            |          |           |         | Packaging 3 - 6 - B4B |           |                                                                                    |
|       |                             |       |            |          |           |         | Packaging 3 - 7 - B4B |           |                                                                                    |



**Container No:** S192070



**Part:** RBE350A93-3201-00

**Job No:** 194253

**Serial No/Batch:** S192070

**Revision:** 1

**Inspector:**

**Exp Date:**

**Instructions:**

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Date: 06/19/19

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|     |            |       |         |                        |                 |
|-----|------------|-------|---------|------------------------|-----------------|
|     |            |       |         | Packaging 3 - 8 - B4B  |                 |
|     |            |       |         | Packaging 3 - 9 - B4B  |                 |
|     |            |       |         | Packaging 3 - 10 - B4B |                 |
|     |            |       |         | Packaging 3 - 11 - B4B |                 |
|     |            |       |         | Packaging 3 - 12 - B4B |                 |
|     |            |       |         | Packaging 3 - 13 - B4B |                 |
|     |            |       |         | Packaging 3 - 14 - B4B |                 |
|     |            |       |         | Packaging 3 - 15 - B4B |                 |
|     |            |       |         | Packaging 3 - 16 - B4B |                 |
|     |            |       |         | Packaging 3 - 17 - B4B |                 |
|     |            |       |         | Packaging 3 - 18 - B4B |                 |
|     |            |       |         | Packaging 3 - 19 - B4B |                 |
|     |            |       |         | Packaging 3 - 20 - B4B |                 |
|     |            |       |         | Packaging 3 - 21 - B4B |                 |
|     |            |       |         | Packaging 3 - 22 - B4B |                 |
|     |            |       |         | Packaging 3 - 23 - B4B |                 |
|     |            |       |         | Packaging 3 - 24 - B4B |                 |
|     |            |       |         | Packaging 3 - 25 - B4B |                 |
|     |            |       |         | Packaging 3 - 26 - B4B |                 |
|     |            |       |         | Packaging 3 - 27 - B4B |                 |
|     |            |       |         | Packaging 3 - 28 - B4B |                 |
|     |            |       |         | Packaging 3 - 29 - B4B |                 |
|     |            |       |         | Packaging 3 - 30 - B4B |                 |
|     |            |       |         | Packaging 3 - 31 - B4B |                 |
|     |            |       |         | Packaging 3 - 32 - B4B |                 |
|     |            |       |         | Packaging 3 - 33 - B4B |                 |
|     |            |       |         | Packaging 3 - 34 - B4B |                 |
|     |            |       |         | Packaging 3 - 35 - B4B |                 |
|     |            |       |         | Packaging 3 - 36 - B4B |                 |
| 140 | QC 21 - FG | 2 pcs | 6/25/19 | 0.00 0.00              | QC 21 - FG - 21 |
|     |            |       |         |                        | QC 21 - FG - 70 |
|     |            |       |         |                        | QC 21 - SA - 53 |

DAG

21

2-50

JUN 21 2019

Part Op 100 - (Small Fab) Assemble as per drawing.  
 Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)  
 130 - (Identify as per dwg & Stock Location: \_\_\_\_\_) Identify and Stock  
 140 - (QC21- Final Inspection - Work Order Release)

## Job BOM

| Part / Item          | Component Name                         | Quantity     | Operation         | Container |
|----------------------|----------------------------------------|--------------|-------------------|-----------|
| 92005A215            | Pan Head Machine Screw, M4 X 0.7 X 6mm | 2 Ea (1 ea)  | 100-Small Fab - 1 | 5148145   |
| RBE350A93-3201-00-20 | Extractor                              | 2 pcs (1 ea) | 100-Small Fab - 1 | 5180111   |
| RBE350A93-3201-00-21 | Bolt (Modified B/O)                    | 2 pcs (1 ea) | 100-Small Fab - 1 | 5184739   |
| RBE350A93-3201-00-22 | Washer                                 | 2 pcs (1 ea) | 100-Small Fab - 1 | 5184993   |
| RBE350A93-3201-00-23 | Sleeve                                 | 2 pcs (1 ea) | 100-Small Fab - 1 | 5187265   |

## Job Allocations

| Operation         | Component Part       | Required | Inventory | Allocated |
|-------------------|----------------------|----------|-----------|-----------|
| 100-Small Fab - 1 | 92005A215            | 2        | 99        | 0         |
|                   | RBE350A93-3201-00-20 | 2        | 0         | 0         |
|                   | RBE350A93-3201-00-21 | 2        | 0         | 0         |
|                   | RBE350A93-3201-00-22 | 2        | 0         | 0         |
|                   | RBE350A93-3201-00-23 | 2        | 0         | 0         |

## Part Specifications

Specifications could not be found.

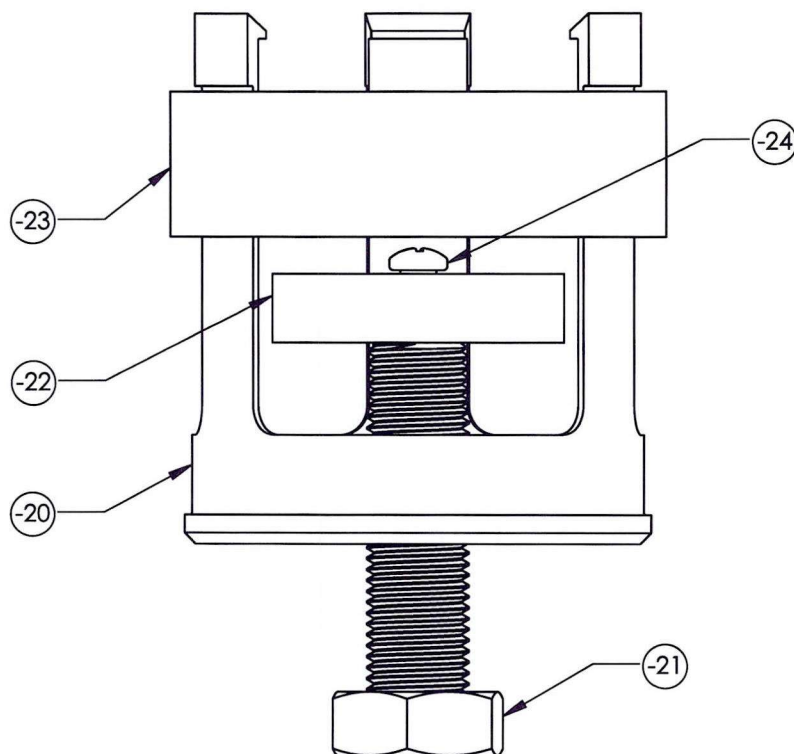
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| REVISIONS |                                                                                                                                                                   |         |         |          |
|-----------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------|---------|----------|
| REV       | DESCRIPTION                                                                                                                                                       | DATE    | INITIAL | APPROVED |
| 1         | REDREW PRINT, CH'D -20 ANGLE FROM 60°, CH'D TIP FROM .032, ADDED -21 SCREW M4 X .7 $\nabla$ .300 HOLE TO TIP, ADDED -22 MISSING .374 THICKNESS DIMENSION PER G.E. | 3/26/12 | RJC     | GE       |

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WITHOUT NOTICE  
WORK ORDER  
NO. 194253 M15  
1904-29



NOTE  
REF OLD RB T/N: RBEA93-3201-00

|                                                                                                                                            |                |
|--------------------------------------------------------------------------------------------------------------------------------------------|----------------|
| <b>RED BARN MACHINE</b>                                                                                                                    |                |
| <b>POWER RING EXTRACTOR</b>                                                                                                                |                |
| DWG NO. RBE350A93-3201-00                                                                                                                  | REV 1          |
| <b>MAT'L</b><br>UNLESS OTHERWISE SPECIFIED<br>DIMENSIONS ARE IN INCHES<br>.XXX ± .005 FRACTIONS ± 1/32<br>.XX ± .01 ANGLES ± 5°<br>.X ± .1 |                |
| <b>DRAWN BY:</b> CLOUGH<br><b>APPROVED:</b> <i>D Weil</i><br><b>HEAT TREAT FINISH:</b><br><b>SPEC:</b>                                     |                |
| 1. BREAK ALL SHARP EDGES .015 x 45°<br>OR .015R<br>2. DIMENSIONAL LIMITS APPLY AFTER PLATING                                               |                |
| USED ON MODEL<br><b>EUROCOPTER 350</b>                                                                                                     |                |
| SCALE 1:1                                                                                                                                  | DATE 3/23/2012 |
| SHEET 1 OF 5                                                                                                                               |                |

| ASSY QTY | ASSY QTY | B/O | Part # | UNIT QTY | Description            | Material  | B/O INFORMATION OR SPECIFICATIONS                    | PG. |
|----------|----------|-----|--------|----------|------------------------|-----------|------------------------------------------------------|-----|
|          |          |     | -20    | 1        | EXTRACTOR              | 4140 Q&T  | Ø2-3/4 X 3                                           | 2   |
|          |          |     | -21    | 1        | BOLT                   | STEEL     | M14 X 1.5 X 60mm MCMaster-CARR #91180A381 (MODIFIED) | 3   |
|          |          |     | -22    | 1        | WASHER                 | 1018      | Ø1-3/4 X 1/2                                         | 4   |
|          |          |     | -23    | 1        | SLEEVE                 | DOM STEEL | Ø2-3/4 X 7/32 WALL X 15/16                           | 5   |
|          |          | B/O | -24    | 1        | PAN HEAD MACHINE SCREW | STEEL     | M4 X .7 X 6mm MCMaster-CARR #92005A215               | 1   |

Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                        |              |  |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------|--------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                        | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                        |              |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                                  | Sequence #:                                                                                                                       | QTY Affected :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                        | MRB (QSI042) |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | Disposition            |              |  |
|                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | Completed By           |              |  |
|                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | Lead hand / Supervisor |              |  |
|                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | QC / QA Coordinator    |              |  |
| <b>Root Cause</b><br><br>Operator <input type="checkbox"/><br>Manufacturing Process <input type="checkbox"/><br>Equip/Tooling <input type="checkbox"/><br>Handling/Preservation <input type="checkbox"/><br>Material <input type="checkbox"/><br>Product Improvement <input type="checkbox"/><br>Process Improvement <input type="checkbox"/><br>Human Factors <input type="checkbox"/> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex; justify-content: space-between;"> <div> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |                        |              |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                        |              |  |